

SPLIT-

Work Order ID 82286-

82286

March-28-12 12:54:08 PM

Item ID: D4436-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft Bracket Assembly
Start Date: 28/03/2012 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 11/04/2012 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/28 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4436	A

100
100
Small Fab
Small Fab
Memo
Assemble as per dwg and intall grommet
0.00
0.00
4
12-08-29

110
110
QC
Quality Control
QC5- Inspect part completeness to step on W/O
Memo
0.00
0.00
4
12-8-29
DAS 16 2-83
8/6/29

160
160
Packaging
Packaging
Identify as per dwg & Stock Location: 273
Memo
0.00
0.00
4
SL 12/8/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82286***82286***

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Item ID: D4436-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCS 12/08/30

ME
12-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 82286

82286

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
RevB 11.12.22 per PA2 EC verified by:JLM
12.01.24 PER DWG REV.A DD VERF:EC

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4440-1		Manufactured	No			100	Each	80.0000	1	6			
D4440-1													
Grommet													
**													
(4) FF 12-08-29													

Location	Loc Qty	Loc Code
GA	77	
80645	77	
prelim	2	
74759	2	
ST139F	1	
79372	1	

D4435-043		Manufactured	No			100	Each	3.0000	1	6			
D4435-043													
Mount Bracket Assembly													
**													
(4) FF 12-08-29													

Location	Loc Qty	Loc Code
ST	-7	
79612	3	
ST139E	10	

D4436-043		Manufactured	No			100	Each	0.0000	1	6			
D4436-043													
Aft Outboard Bracket Assembly													
**													
(4) FF 12-08-29													

D4436-045		Manufactured	No			100	Each	1.0000	1	6			
D4436-045													
Aft Inboard Bracket Assembly													
**													
(4) FF 12-08-29													

Location	Loc Qty	Loc Code
GA	1	
80760	1	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 82286

82286

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

AN525-832R6

Purchased

No

100

Each

343.0000

4

24

AN525-832R6

**

Screw

④ FF 12-08-29

Location

Loc Qty

Loc Code

ST345

343

120308

1

120560

342

816

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

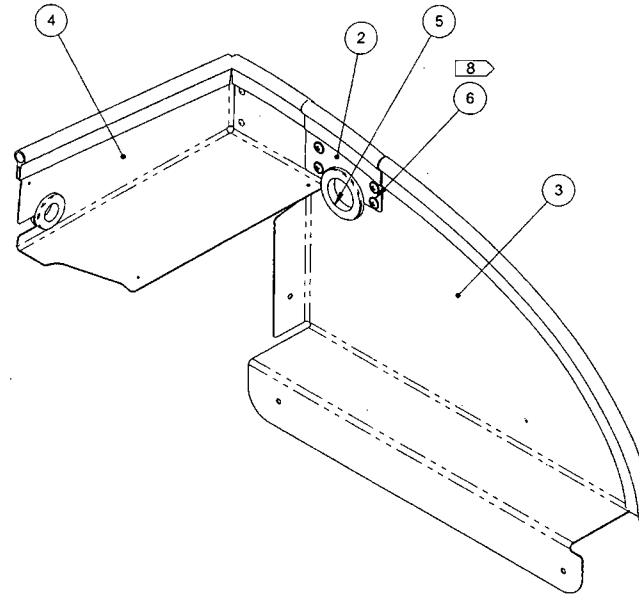
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82286 MLJ
12/03/28

RELEASED
12 2012-01-23
MP

D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF	SHEET 1 OF 7	
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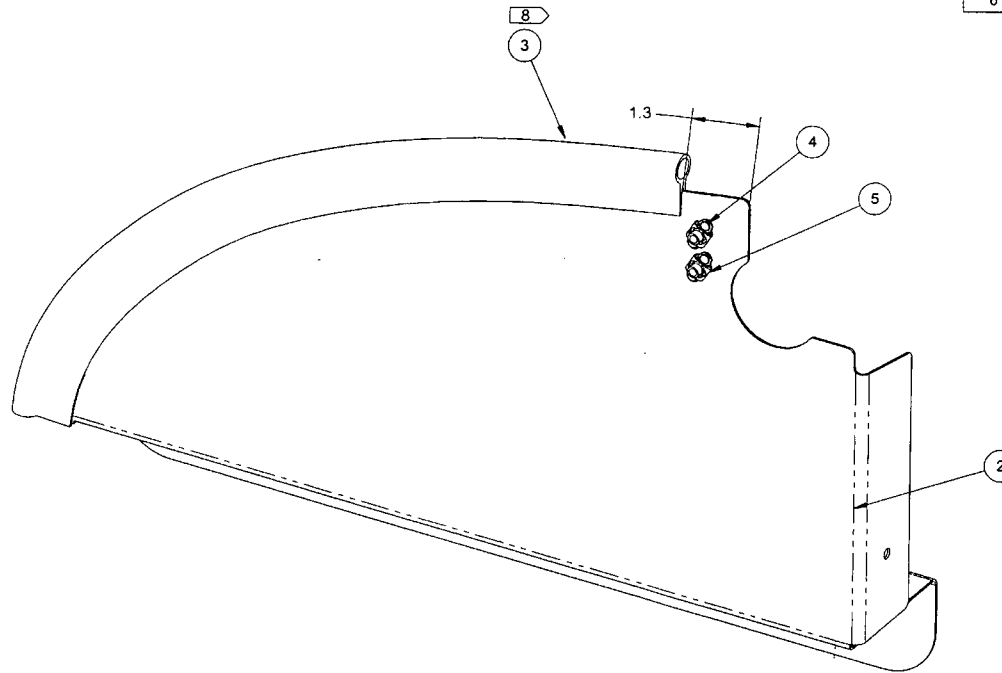
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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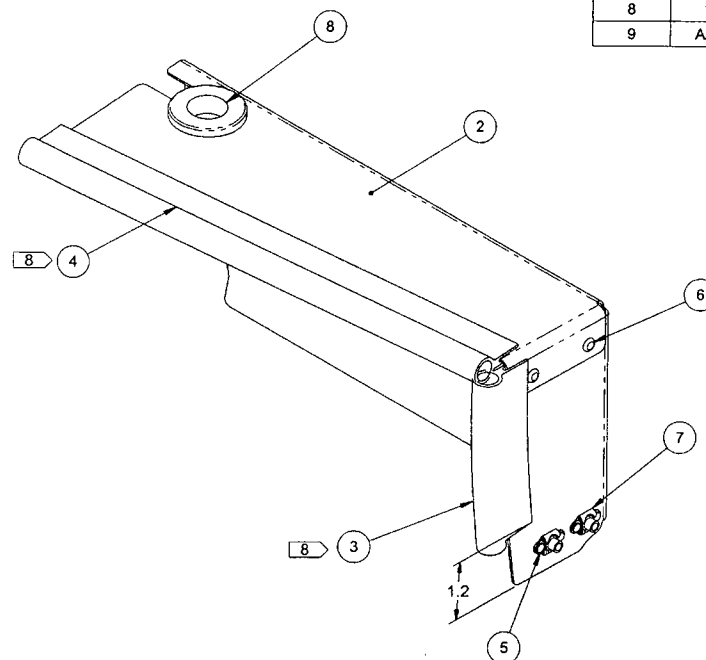
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE, ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL. IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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82286

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2012-01-23
MP

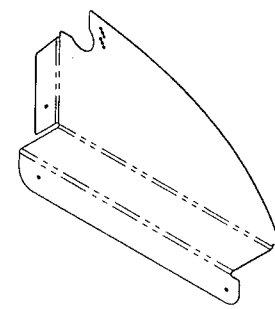
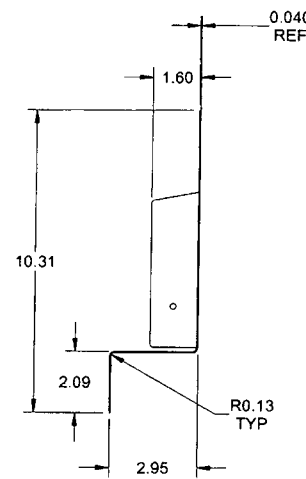
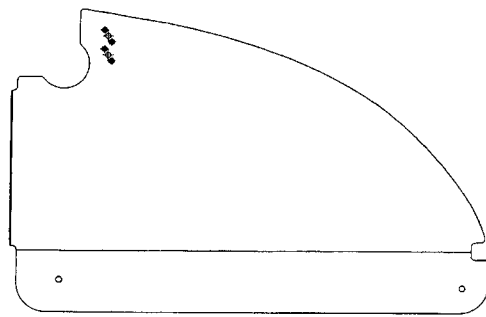
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



82286

D4436-1 BRACKET

RELEASE
2012-01-23

NOTES:

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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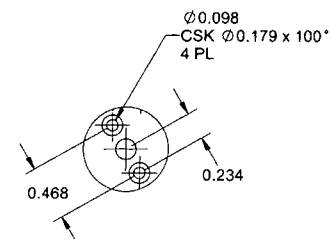
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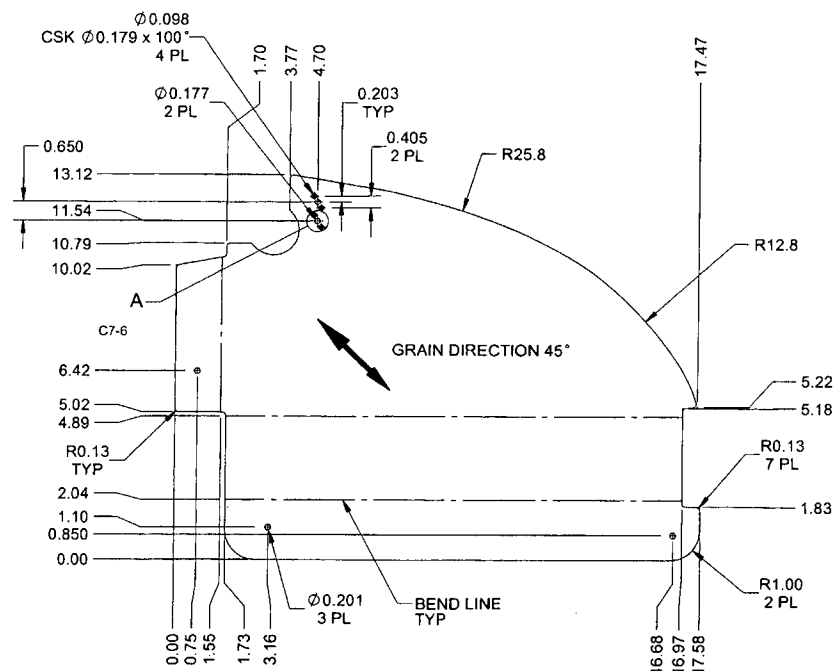
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NOTE: Date & initial all entries



DETAIL A C6-6
SCALE 4X, TYP



D4436-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD	
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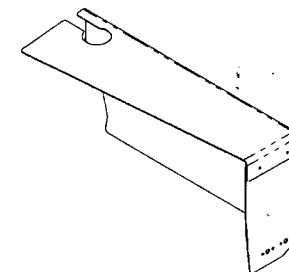
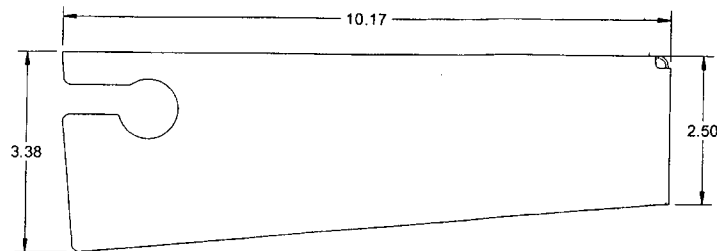
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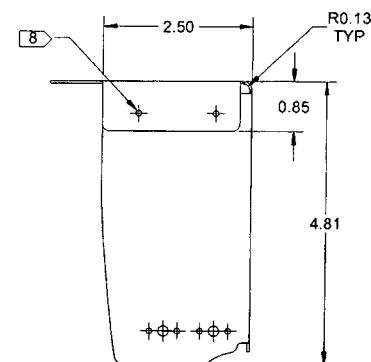
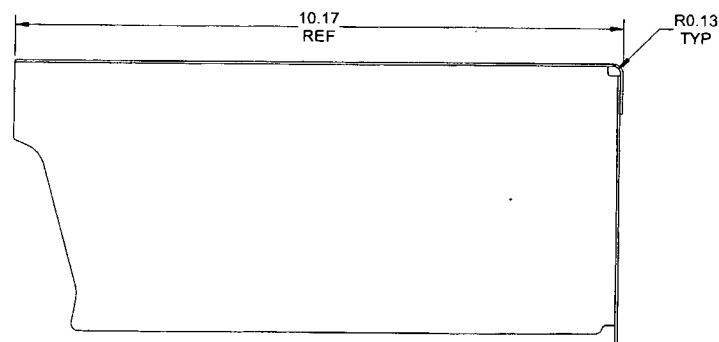
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NOTE: Date & initial all entries



92286



D4436-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 2 PLACES

RELEASE

2012-01-23

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